

5/32

9/1st

23866

DART AEROSPACE LTD		Work Order:	<del>H-307</del>
Description: Litter Tie Down Bracket		Part Number:	D2363
Drawing: <del>D2363 Rev E</del> D3179 REV A		Qty:	<del>2</del> 105

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O			
2	METAL	Cut blanks 12.15" long Material: 6061-T6 (QQ-A-200/8) 4"x4"x3/8" Thick 'T' ext. Batch B19492		05.07.22	5
3	HAAS	Machine as per folio <del>D2363</del> FA 297	J.L	05.07.22	5
4	QC	Inspect Level 2	ML	05/07/24	5
5	QC	Inspect Level 8	ML	05/07/24	5
6	METAL	Deburr	ML	05.07.25	5
7B	QC 5	Inspect Level 7 work for completeness on the w/o	ML	05/07/25	5
7A	FP	Acid etch and Alodine per Q31 005 4.1	ML	05.07.25	5
8	PURCHASING FP	Issue P.O. Red anodize		05-7-25	5
9	QC	Inspect Level 3			
10	STORES	Identify and stock			
11	EXPEDITING	Close W/O 74.55 Cost / part: 74.55 Inspect Level 21	DL	05/07/26	5

Rev.	Date	Change	Revised By	Approved
A	95.02.20	New Issue 02-02.09		
B	99.04.22	Re-format, Machining in house		
C	00.05.18	Added inspection level 8	DM	
A1	03.01.09	Added Acid etch and Alodine	EC	

RELEASED

00.05.24

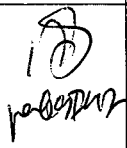
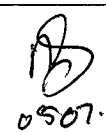
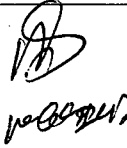
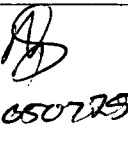
02.12.09

Relo. 142

12/24/05

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.07.23	3						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.23	3	Ø.191 hole drilled to Ø.242.		Wrong drill size used. Destroy & Replace	BG 05.07.23	 05.07.23		 05.07.23

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 05/07/26

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

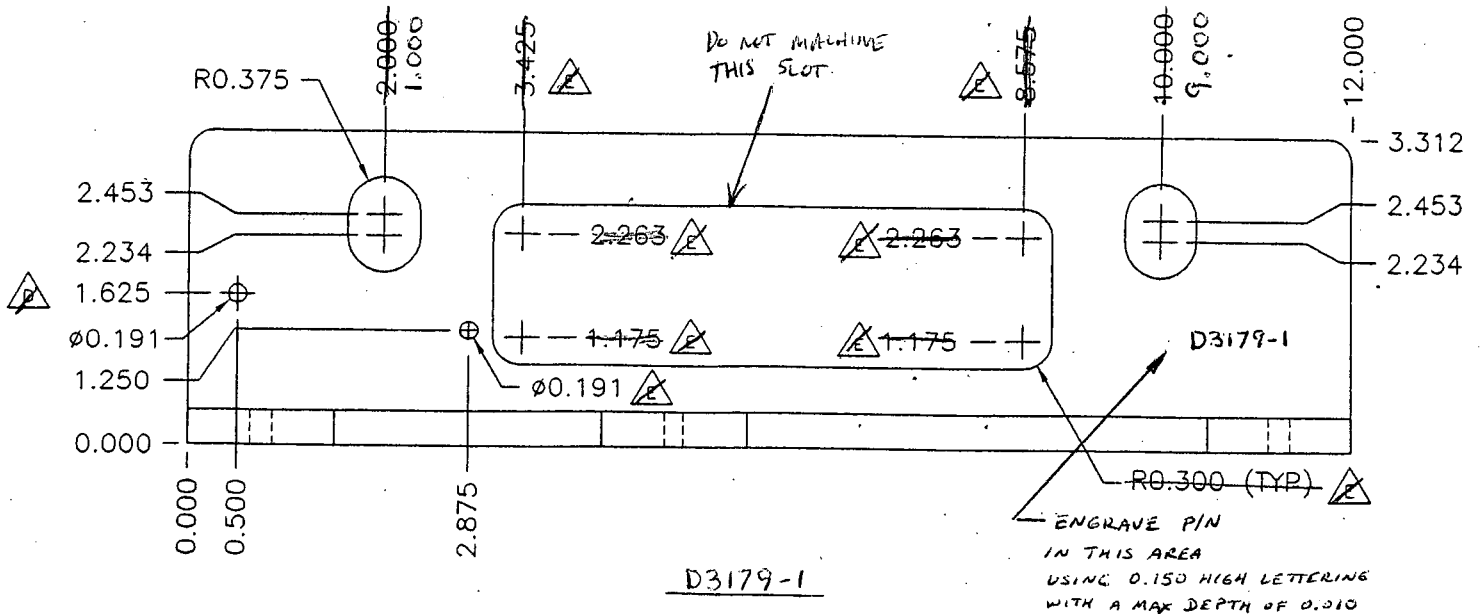
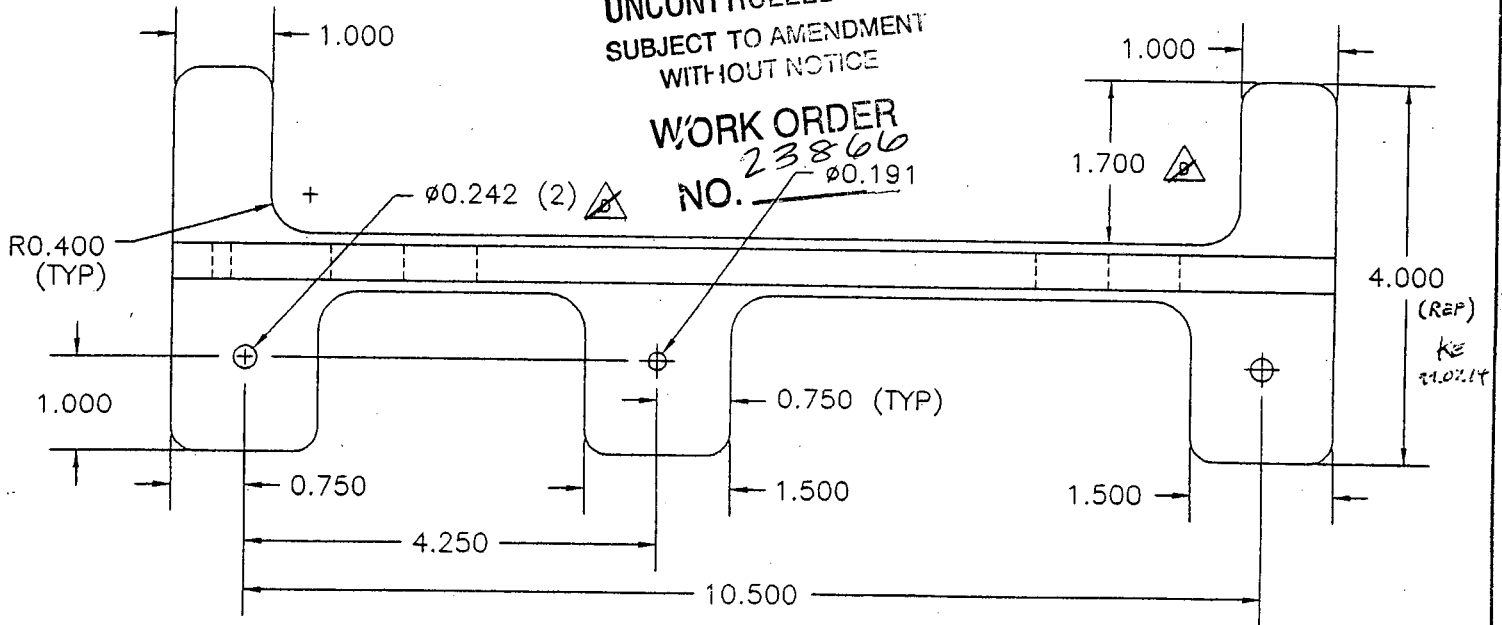


DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED DIOY	APPROVED BW	DRAWING NO. D2363 D3179	REV. E SHEET 1 OF 1
DATE 97.10.01	TITLE LITTER TIE DOWN BRACKET		
A		02.12.09 95.01.14	NEW ISSUE
B		95.02.14	MODIFIED HOLES
C		95.03.06	0.191 WAS 0.187
D		95.03.06	CHANGES TO DIMENSIONS
E		97.10.01	CHANGES FOR MACHINING

RELEASED  
971003 KE  
TSR 4124

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
23866  
NO. 00.191



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION  
FINISH: ANODIZE MAKE FROM EXTRUSION D6201

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 22, 2005  
09:28 am

Work Order No : 0023866  
Project Name : D3179-1  
Project For : WK532  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3179-1  
Description : Litter Tie Down Bracket  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 07-22-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :


Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

252

X	First Article	X	Prototype
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Measured by:	BC	Audited by:		Prototype Approval:	N/A
Date:	05.07.23	Date:	05.07.25	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revD

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 23866
<b>Description:</b> Litter tie down bracket	<b>Part Number:</b> 03179
<b>Inspection Dwg:</b> 03179 <b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	±.010	1.000	✓			
1.700	"	1.695	✓			
1.000	"	1.001	✓			
4.000	"	3.995	✓			
1.500	"	1.501	✓			
1.500	"	1.501	✓			
10.500	"	10.500	✓			
4.250	"	4.251	✓			
.750	"	.752	✓			
1.000	"	.999	✓			
12.400	"	12.400	✓			
φ.242	+0.005 -0.000	.243	✓			
φ.191	+0.005 -0.000	.193	✓			
12.375	±.010	12.374	✓			
1.000	"	1.005	✓			
9.000	"	9.005	✓			
12.000	"	12.002	✓			
3.312	"	3.310	✓			
2.453	"	2.447	✓			
2.234	"	2.237	✓			
φ.191	+0.005 -0.000	.192	✓			
2.875	±.010	2.873	✓			
.500	"	.500	✓			

<b>Measured by:</b> TBC	<b>Audited by:</b>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 05.07.23	<b>Date:</b>	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	